

Date: Friday, 13/02/2009 1:02:40 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 45797	
Estimate Number : 10347	
P.O. Number :	Part Number : D28572
This Issue : 13/02/2009 S.O. No. :	Drawing Number : D2857 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 43363	Material :
Written By :	Due Date : 20/02/2009 Qty: 24 Um: Each
Checked & Approved By : <u>JUD 09.02.13</u>	
Comment : Est C 00.06.22 Removed P/O for powder coat EC Est D 06.03.30 Added level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2000X01250	6061-T6 Bar 2.00 x 1.25
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Comment: Qty.: 0.4594 f(s)/Unit Total : 11.0250 f(s)

Material: 2.00" X 1.25"

6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)

(M6061T6B200001250)

Batch M103858 + 12 1/4 100451

mat Not in computer (24)

mmf 09/02/16

2.0	BAND SAW	BAND SAW
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(24)

Comment: BAND SAW

Cut blanks 5.2"

mmf 09/02/16

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2857-2

2-Debur any rough edges

(P/O)

mmf 09/02/19

88 09/02/18

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 09/02/19

88 09/02/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2857-2 PAR #: N/A Fault Category: Prod/Machined Parts NCR: (Yes) No DQA: A Date: 29/03/03
 Resolution: D350-600 142 Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: <u>45797</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/02/17</u>	<u>3.0</u>	<u>One part pop out of the vise on the 2nd operation</u> <u>R.C operator error</u>	<u>[Signature]</u> <u>bs1w2</u>	<u>Scrap destroy?</u> <u>Replace Qty 1.</u> <u>Batch M100451</u>	<u>[Signature]</u> <u>07/02/18</u>	<u>[Signature]</u> <u>09/02/20</u>	<u>[Signature]</u> <u>bs1w2</u>	<u>[Signature]</u> <u>bs-02-19</u>
<u>↓</u>	<u>↓</u>	<u>Did not tight the vise enough</u>	<u>[Signature]</u> <u>bs1w2</u>				<u>[Signature]</u> <u>bs1w2</u>	<u>[Signature]</u> <u>bs-02-19</u>

NOTE: Date & initial all entries

Date: Friday, 13/02/2009 1:02:40 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 45797

Part Number: D28572

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

26 09/02/20

(26)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

FL 09/02/23

(26)

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

u/s

8.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

M109996

START TIME: 10:20 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 10:50 AM

JM 09-02-24

(x26)

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

SL 09-02-24

(26)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *SS1*

10/2/25 (26)

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/02/25

Job Completion



u 09.02.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45797
Description: Hinge Bracket		Part Number: D2857-2
Inspection Dwg: D2857	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

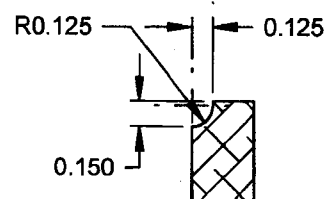
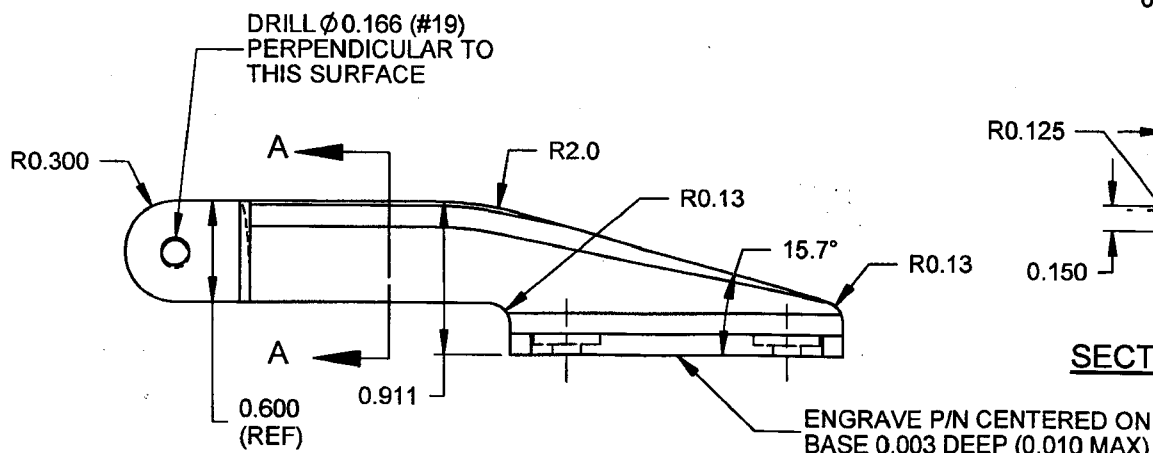
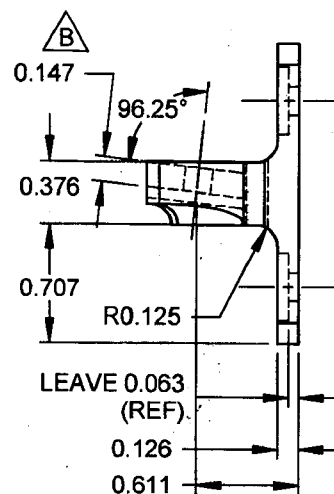
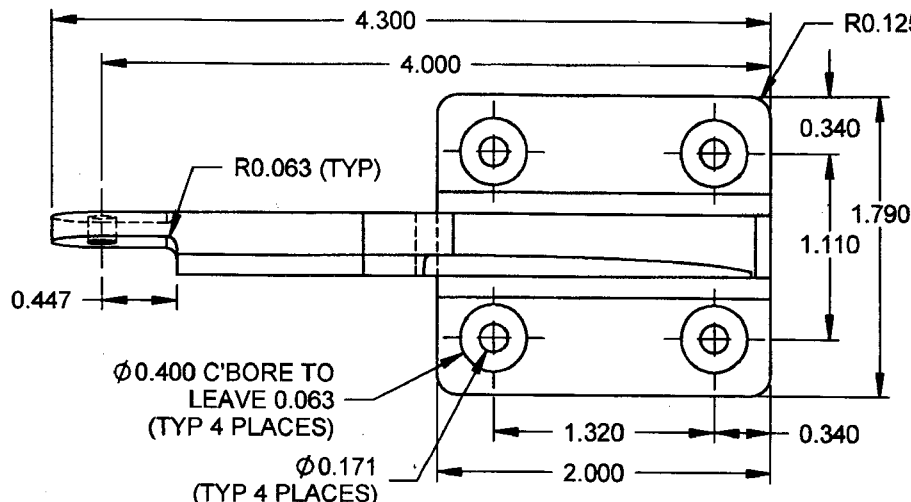
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.306	✓			
4.000	+/-0.010	4.006	✓			
0.340	+/-0.010	.342	✓			
1.110	+/-0.005	1.100	✓			
1.790	+/-0.010	1.793	✓			
1.320	+/-0.005	1.322	✓			
2.000	+/-0.010	2.005	✓			
0.340	+/-0.010	.342	✓			
0.447	+/-0.010	.449	✓			
Ø0.171	+0.005/-0.000	.173	✓			
0.147	+/-0.010	.140	✓			
0.376	+/-0.010	.378	✓			
0.126	+/-0.010	.128	✓			
0.063	+/-0.010	.063	✓			
Ø0.166	+0.005/-0.000	.166	✓			
0.911	+/-0.010	.917	✓			
0.600	+/-0.010	.610	✓			
0.125	+/-0.010	.128	✓			
0.150	+/-0.010	.148	✓			

Measured by: <i>SP/mw</i>	Audited by: <i>ml</i>	Prototype Approval:	N/A
Date: 09/02/17	Date: 09/02/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	<i>[Signature]</i>

DART

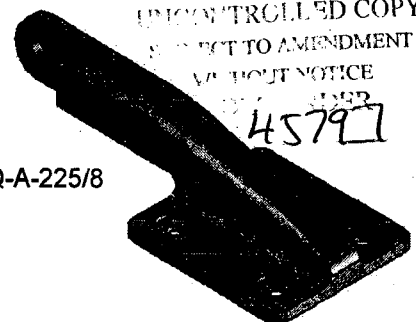
DESIGN KE	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2857
DATE 06.08.28	TITLE HINGE BRACKET	REV. B SHEET 1 OF 1 SCALE 1:1
REV	DATE	DESCRIPTION
A	98.12.14	NEW ISSUE
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS

RELEASED
06-10-13**SECTION A-A****D2857-1 HINGE BRACKET**
D2857-2 OPPOSITE**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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